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UTILITY PATENT APPLICATION TRANSMITTAL
(Large Entity)

(Only for new nonprovisional applications under 37 CFR 1.53(b))

Docket No. 769-236 Div.
Total Pages in this Submission 49

TO THE ASSISTANT COMMISSIONER FOR PATENTS
Box Patent Application
Washington, D.C. 20231

Transmitted herewith for filing under 35 U.S.C. 111(a) and 37 C.F.R. 1.53(b) is a new utility patent application for an invention entitled:

METHODS OF MAKING SLIDE ZIPPERED RECLOSABLE PACKAGES ON HORIZONTAL FORM-FILL-SEAL MACHINES

and invented by:

Michael J. McMahon, Art Malin & Steve Ausnit

If a CONTINUATION APPLICATION, *check appropriate box and supply the requisite information:*

☐ **Continuation** ☒ **Divisional** ☐ **Continuation-in-part (CIP)** of prior application No.: **09/316,866**

Which is a:

☐ **Continuation** ☐ **Divisional** ☐ **Continuation-in-part (CIP)** of prior application No.: _____

Which is a:

☐ **Continuation** ☐ **Divisional** ☐ **Continuation-in-part (CIP)** of prior application No.: _____

Enclosed are:

Application Elements

1. ☒ Filing fee as calculated and transmitted as described below
2. ☒ Specification having 22 pages and including the following:
   - a. ☒ Descriptive Title of the Invention
   - b. ☒ Cross References to Related Applications *(if applicable)*
   - c. ☐ Statement Regarding Federally-sponsored Research/Development *(if applicable)*
   - d. ☐ Reference to Microfiche Appendix *(if applicable)*
   - e. ☒ Background of the Invention
   - f. ☒ Brief Summary of the Invention
   - g. ☒ Brief Description of the Drawings *(if drawings filed)*
   - h. ☒ Detailed Description
   - i. ☒ Claim(s) as Classified Below
   - j. ☒ Abstract of the Disclosure

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Application Elements (Continued)

3. ☒ Drawing(s) *(when necessary as prescribed by 35 USC 113)*
   a. ☒ Formal Number of Sheets 12
   b. ☐ Informal Number of Sheets _____
4. ☒ Oath or Declaration
   a. ☐ Newly executed *(original or copy)* ☐ Unexecuted
   b. ☒ Copy from a prior application (37 CFR 1.63(d)) *(for continuation/divisional application only)*
   c. ☒ With Power of Attorney ☐ Without Power of Attorney
   d. ☐ *DELETION OF INVENTOR(S)*
   Signed statement attached deleting inventor(s) named in the prior application, see 37 C.F.R. 1.63(d)(2) and 1.33(b).
5. ☐ Incorporation By Reference *(usable if Box 4b is checked)*
   The entire disclosure of the prior application, from which a copy of the oath or declaration is supplied under Box 4b, is considered as being part of the disclosure of the accompanying application and is hereby incorporated by reference therein.
6. ☐ Computer Program in Microfiche *(Appendix)*
7. ☐ Nucleotide and/or Amino Acid Sequence Submission *(if applicable, all must be included)*
   a. ☐ Paper Copy
   b. ☐ Computer Readable Copy *(identical to computer copy)*
   c. ☐ Statement Verifying Identical Paper and Computer Readable Copy

Accompanying Application Parts

8. ☒ Assignment Papers *(cover sheet & document(s))*
9. ☐ 37 CFR 3.73(B) Statement *(when there is an assignee)*
10. ☐ English Translation Document *(if applicable)*
11. ☐ Information Disclosure Statement/PTO-1449 ☐ Copies of IDS Citations
12. ☒ Preliminary Amendment
13. ☒ Acknowledgment postcard
14. ☒ Certificate of Mailing
    ☐ First Class ☒ Express Mail *(Specify Label No.):* EK839444925US

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Accompanying Application Parts (Continued)

15. ☐ Certified Copy of Priority Document(s) *(if foreign priority is claimed)*

16. ☒ Additional Enclosures *(please identify below):*

Copy of Associate Power of Attorney from parent case

Fee Calculation and Transmittal

CLAIMS AS FILED

For	#Filed	#Allowed	#Extra		Rate	Fee
Total Claims	28	- 20 =	8	x	$18.00	$144.00
Indep. Claims	4	- 3 =	1	x	$78.00	$78.00
Multiple Dependent Claims (check if applicable) ☐						$0.00
					BASIC FEE	$690.00
OTHER FEE *(specify purpose)*	Recording assignment for new serial number					$40.00
					TOTAL FILING FEE	$952.00

☐ A check in the amount of to cover the filing fee is enclosed.

☒ The Commissioner is hereby authorized to charge and credit Deposit Account No. 50-1145 as described below. A duplicate copy of this sheet is enclosed.

- ☒ Charge the amount of $952.00 as filing fee.
- ☒ Credit any overpayment.
- ☒ Charge any additional filing fees required under 37 C.F.R. 1.16 and 1.17.
- ☐ Charge the issue fee set in 37 C.F.R. 1.18 at the mailing of the Notice of Allowance, pursuant to 37 C.F.R. 1.311(b).

Signature

Dated: August 2, 2000

Gerald Levy
Reg. No. 24,419
PITNEY, HARDIN, KIPP & SZUCH LLP
711 Third Avenue
20th Floor
New York, New York 10017

(212)687-6000

cc:

769-236 Div.

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant: Michael J. McMahon, Art Malin and Steve Ausnit

Serial No.: **N/A**

Filed: Herewith

Art Unit: 3721 (Parent Case)

For: **METHODS OF MAKING SLIDE ZIPPERED RECLOSABLE PACKAGES ON HORIZONTAL FORM-FILL-SEAL MACHINES**

Examiner: D. Moon (Parent Case)

711 Third Avenue
New York, New York 10017
(212) 687-6000

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents
Washington, D.C. 20231

S I R:

Prior to any action in the above captioned case, kindly amend the application as follows:

I hereby certify that this correspondence is being deposited with the United States Postal Service as first class mail in an envelope addressed: Assistant Commissioner for Patents, Washington, D C 20231, on **August 2, 2000**

Gerald Levy
Attorney

Signature

August 2, 2000
Date of Signature

The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Account No 50-1145, Order No 769-236 Div.

612998A01073100

In the specification:

Page 1, line 6, after Title of the Invention, please insert the following: --**CROSS REFERENCE TO RELATED APPLICATIONS.** This is a division of U.S. Patent Application serial number 09/316,866 filed on May 21, 1999.--

In the claims:

Cancel claims 1 – 5.

Remarks

The present amendment is being submitted herewith to cancel all of the claims of the parent case, except for claims 6 - 33 for prosecution in the divisional application filed herewith.

An early action on the merits is respectfully requested.

Respectfully submitted,

Gerald Levy
Reg. No. 24,419

769-236

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re of the application of: Michael J. McMahon, et al.

Serial No. **09/316,866**

Filed: May 21, 1999

Art Unit: 3626

For: **METHODS OF MAKING SLIDE-ZIPPERED RECLOSABLE PACKAGES ON HORIZONTAL FORM-FILL-SEAL MACHINES**

711 Third Avenue
New York, New York 10017
(212) 687-6000

ASSOCIATE POWER OF ATTORNEY

Assistant Commissioner for Patents
Washington, D.C. 20231

S I R:

I hereby appoint Thomas W. Buckman (Registration Number 25,756), Donald J. Breh (Registration Number 30,159), John P. O'Brien (Registration Number 22,764) and Mark W. Croll (Registration Number 31,098), as my associate attorneys in the above-entitled application, to inspect and prosecute this application, to make alterations and amendments therein, and to transact all business in the Patent and Trademark Office.

Please continue to address all future communications to:

Gerald Levy, Esq.
Kane, Dalsimer, Sullivan, Kurucz, Levy,
Eisele and Richard, LLP
711 Third Avenue
New York, New York 10017

Respectfully submitted,

Gerald Levy
Reg. No. 24,419

769-236

TITLE OF THE INVENTION

Methods of Making Slide-Zippered Reclosable Packages on Horizontal Form-Fill-Seal Machines

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to the field of reclosable packaging. More particularly, the present invention relates to methods of making reclosable packages having slide zippers on horizontal form-fill-seal (HFFS) machines.

2. Description of the Prior Art

Methods of making reclosable packages on various types of HFFS machines are well-known in the reclosable packaging art, such as that disclosed in U.S. Patent No. 4,876,842. Slide zippers, i.e., plastic zippers opened and closed by a slider, are likewise well-known in the reclosable packaging art. Examples of several types of slide zippers can be found in U.S. Patent Nos. 5,007,143, 5,008,971, 5,131,121 and 5,664,299.

The reclosable packaging art, however, is virtually, if not totally, silent as it relates to the manufacture of slide-zippered packages on HFFS machines. Because of the facility which is provided by slide zippers to consumers of reclosable packages and because of the large volume of reclosable packages made on HFFS machines today, it is highly desirable and advantageous to combine the two technologies so that slide-zippered reclosable packages can be made on HFFS machines.

SUMMARY OF THE INVENTION

Accordingly, the object of the present invention is to provide methods of making slide-zippered reclosable packages on HFFS machines.

According to a first embodiment of the present invention, a chain of packages is formed, filled and sealed on an HFFS machine or the like. A pair of opposing film extensions are provided on each package. As the chain of packages is indexed forwardly, a reclosable zipper is inserted between the film extensions of the leading package and sealed thereto. A slider is then inserted on to the reclosable zipper of the leading package and the completed leading package is cut from the chain.

According to a second embodiment of the present invention, packages having reclosable zippers are output from an HFFS machine or the like, either individually or in a chain. A slider is then inserted on to the zipper of each package in turn.

According to a third embodiment of the present invention, packages are formed, filled and sealed on an HFFS machine or the like. During package formation, a reclosable zipper is sealed to each package and then a slider is inserted on to the zipper.

According to a fourth embodiment of the present invention, packages are formed, filled and sealed on a horizontal form-vertical fill-seal (HVFS) machine or the like. During package formation, a reclosable zipper is sealed to each package and a slider is inserted on to each zipper, either before or after zipper sealing.

The present invention will now be described in detail, with frequent reference being made to the drawings identified below in which the same numerals represent the same elements.

BRIEF DESCRIPTION OF THE DRAWINGS

In the accompanying drawings:

Figure 1 shows packages being made on an HFFS machine in accordance with a first embodiment of the present invention;

Figure 2 is a perspective view of a package made on the HFFS machine of figure 1 prior to attaching the zipper;

Figure 3 is a cross-sectional view of the HFFS machine of figure 1 at the slider insertion point;

Figure 4 is a cross-sectional view of a first variation of the HFFS machine of figure 1;

Figure 5 shows sliders being inserted on a chain of packages in accordance with a second embodiment of the present invention;

Figure 6 shows sliders being inserted on to individual packages in accordance with a variation of the second embodiment of the present invention;

Figure 7 shows packages being made on an HFFS machine in accordance with a third embodiment of the present invention;

Figure 7a is a cross-sectional view of the HFFS machine of figure 7 at the first zipper sealing station;

Figure 8 is a cross-sectional view of the HFFS machine of figure 7;

Figure 9 is a cross-sectional view of a package made on the HFFS machine of figure 7;

Figure 10 shows packages being made on an HFFS machine in accordance with a variation of the third embodiment of the present invention;

Figure 11 is a cross-sectional view of packages being made on the HFFS machine of figure 10;

Figure 12 shows packages being made on an HFVS machine in accordance with a fourth embodiment of the present invention;

Figure 13 shows packages being made on an HFVS machine in accordance with a first variation of the fourth embodiment of the present invention;

Figure 14 shows packages being made on an HFVS machine in accordance with a second variation of the fourth embodiment of the present invention;

Figure 15 is a cross-sectional view of reclosable zipper being sealed to one package side in the HFVS machine of figure 14;

Figure 16 is a cross-sectional view of a package prior to being filled on the HFVS machine of figure 14;

Figure 17 is a cross-sectional view of a tamper evident sealed being placed on a package made on the HFVS machine of Fig. 14;

Figure 18 shows packages being made on an HFVS machine in accordance with a third variation of the fourth embodiment of the present invention; and

Figure 19 is a cross-sectional view of a package being formed on the HFVS machine of figure 18.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

In accordance with a first embodiment of the present invention, figure 1 shows how slide-zippered packages can be made on a typical thermoform HFFS machine 10. Forming

film 12 is indexed off a coil 14 of the same in a package forming direction. Downstream of the forming film coil 14 at a forming station 15 the forming film 12 is thermoformed, using techniques well-known to those of ordinary skill in the reclosable packaging art, into a chain 13 of advancing box-like bottom portions or trays 16 of what will ultimately be completed packages. Product may then be loaded into the bottom portions 16 at a loading station 17 if desired. After optional product loading, top film 18 is indexed off a coil 20 of the same in the package forming direction, laid over the advancing bottom portions 16 and perimeterly sealed thereto at four locations 22, 24, 26, 28 at a sealing station 21 to form a sealed package 29, as shown in figure 2. The seal at the package opening 22 takes the form of a peel seal so that the consumer can easily gain access to the contents of the package.

As shown in figure 2, which is a perspective view of a sealed package 29 formed on the thermoform HFFS machine of figure 1 prior to zipper and slider insertion, the bottom portion 16 and top film 18 are each provided with film extensions 30, 32 which extend beyond the peel seal 22 on one side of the package 29. The film extensions 30, 32 are not sealed to each other and may readily be spread apart from each other.

After the top film 18 is sealed to the bottom portion 16 at the sealing station 21, the package chain 13 enters a zipper and slider insertion and attaching station 34. At this station 34 the film extensions 30, 32 of the leading package are spread apart from each other and interlocked reclosable zipper 36 supplied from a coil 38 of the same is fed between the film extensions 30, 32, as shown in figure 3, which is a cross-sectional view of the package chain and zipper and slider insertion and attaching station 34. The zipper is comprised of two interlocking closure elements 39, 41 and flanges 40, 42 extending therefrom which are sealed

to the film extensions 30, 32, such as by a pair of seal bars (not shown). After the zipper 36 is thus sealed to the film extensions of the leading package, the zipper 36 is stomped at each end of the package by a stomping apparatus (not shown) to provide end stops for the slider and to ensure that the ends of the zipper 36 do not come apart during use.

A slider 44 is then removed from a coil 46 thereof and inserted on to the zipper 36 by a slider insertion apparatus (not shown). The slider and zipper are designed such that the slider will open the zipper as the slider is moved along the zipper in an opening direction towards an opening end of the zipper and close the zipper as the slider is moved along the zipper in a closing direction towards a closing end of the zipper. It is preferable during slider insertion that the slider be inserted at the closing end of the zipper since the zipper is initially interlocked. The slider will thus be positioned for normal functioning. If the slider is inserted at a location other than at the closing end, it will be necessary to actuate the slider by moving it to the closing end, after which the slider will be in position for normal functioning. Such actuation may be done on the HFFS machine, or it may be done by the initial package user.

After slider insertion, the leading package is cross-cut from the remainder of the chain 13 by any one of many commonly known cutting apparatuses (not shown) to remove a completed package 48 having a slide zipper.

In practice, the package chain 13 may be a single chain as shown in figure 3, or, alternatively, may be a multiple chain, such as the double chain 50 shown in cross-section in figure 4. In the case of a double chain, where two packages are joined side by side, the process of making the packages is virtually identical to that described above, except that the

zippers and sliders are attached to the opposite sides 47, 49 of the package chain simultaneously, as shown in figure 4, thus requiring two zipper and slider insertion and attaching stations 34. Additionally, a second cut is needed in the machine direction along the central axis 51 of the chain to remove the side-by-side packages from one another.

The foregoing embodiment of the present invention is not limited to practice on thermoform HFFS machines, but may be practiced on any type of package making machine where the packages are formed with film extensions 30, 32 of the type discussed above.

Figures 5 and 6 depict a second embodiment of the present invention. Zippered packages 52, either in a chain 54 as shown in figure 5 or individually as shown in figure 6, are output from an HFFS machine (not shown), or any other type of bag making machine. In the case of figure 5, the package chain 54 is indexed into a slider insertion station 56. At the slider insertion station 56 or at an earlier station, the ends of the zipper 36 on the leading package in the chain 54 are stomped as discussed above. Then, a slider 44 is removed from the slider coil 46 and inserted on to the zipper 36. Finally, a completed package 58 have a slide zipper is cross-cut from the chain by a cutting apparatus (not shown).

In the case of figure 6, the packages 52 are individual and not chained together. The individual packages 52 are transported one by one into the slider insertion station 56 by a conveyor belt 60 or the like, where the ends of the zipper 36 on the leading package are stomped (unless the stomping was done during package formation) and a slider 44 is removed from the slider coil 46 and inserted on to the zipper 36 to provide a completed slide-zippered package 58.

In accordance with a third embodiment of the present invention, figure 7 shows a

thermoform HFFS machine 62 configured to make slide-zippered packages. As in figure 1, the forming film 12 is indexed off a coil 14 of the same. Downstream of the forming film coil 14 at a forming station 15 the forming film 12 is thermoformed into a chain 13 of box-like bottom portions or trays 16 of what will ultimately be completed packages. Product may then be loaded into the bottom portions 16 at the loading station 17 if desired. Each bottom portion 16 is provided with a lip 64 on one side thereof, as shown in figure 8, which is a cross-sectional view of the chain 13. After optional product loading, the reclosable zipper 36 is indexed off a coil 38 of the same and laid over the lips 64 of the bottom portions 16. The lower zipper flange 42 is then sealed to the lips 64 by a sealing mechanism, such as a heater bar 63, at a sealing station 68. The heater bar 63 is positioned below the lips 64, as shown in figure 7a, which is a cross-sectional view of zipper attachment to the package lips. Also shown in figure 7a is an insulating and guide plate 67 positioned between the zipper flanges. The insulating and guide plate 67 provides a surface for the heater bar to react against and removes any danger of sealing through the zipper flanges, thereby eliminating the need for accurate heat control. The insulating and guide plate 67 also serves to guide and position the zipper onto the package lips to ensure accurate sealing.

A slider 44 is then removed from the slider coil 46 and inserted on to the zipper 36 of the instant bottom portion 16 at an insertion station 70. After slider insertion, the ends of the zipper are stomped. Alternatively, the zipper ends could have been stomped together earlier, either on the machine or pre-stomped prior to winding on the supply coil, and the zipper indexed to the bottom portion. The top film 18 is then indexed off the top film coil 20, laid over the formed bottoms 16 and the attached zipper 36 and sealed to the formed bottoms 16

and the upper flange 40 of the zipper 36 around the perimeter of the package at a second sealing station 72. As discussed above, the seal at the mouth of the package may take the form of a peel seal to provide easy access to the contents of the package. Optionally, the top film 18, if it is long enough, may be heat tacked to the bottom portion 16 over the zipper 36 to provide a tamper evident seal 65, as shown in figure 9. In the final step, the completed packages 48 are cross-cut from the chain at a cutting station 74. If a double chain is used, as shown in figure 8, then the side-by-side packages must also be cut from each other in the machine direction.

When making packages using multiple package chains, it is not necessary that the zippers and sliders be applied to opposite sides 47, 49 of the package chain, as shown in figures 4 and 8. Rather, it is also possible to apply the zippers and sliders to the same sides of the packages. For example, a triple package chain is shown in figures 10 and 11. In this case the top film 18 is pre-perforated so that it can be split into three sections and laid over each of the bottom portions 16. This splitting is achieved by a separator assembly 78 having three L-shaped separator plates 78a, 78b, 78c. As the top film 18 is indexed off its roll 20, the vertical portions of the separator plates 78a, 78b, 78c split the pre-perforated top film 18 into three portions 18a, 18b, 18c and guide the three top film portions as they are laid over their corresponding bottom portions 16. Additionally, the horizontal portions of the separator plates interact with the sealing mechanism to ensure that there is no seal through, eliminating the need for accurate heat control.

As indicated above, the present invention is not limited to thermoform HFFS machines, but may be practiced on any type of HFFS machine and on any type of bag making

machine for that matter. Figure 12 shows how slide-zippered packages can be made on a horizontal form-vertical fill-seal machine (HFVS) 80 in accordance with a fourth embodiment of the present invention.

Package film 82 is paid off a roll 84 of the same. Downstream a pull roller 98 is provided for driving the film 82 through the machine. A folder plow 86 positioned downstream of the film roll 84 folds the package film 82 about a bottom crease 83 to form opposing package walls 116, 118. Interlocked reclosable zipper 36 is then paid off a roll 38 of the same and fed between the advancing package walls. Sliders 44 are inserted on to the reclosable zipper 36 prior to the folder plow 86 at package width intervals at what will be the closing end of the zipper by a slider insertion mechanism at the slider insertion station 88. The sliders 44 are supplied from the slider coil 46.

At a first sealing station 90, the zipper flanges 40, 42 are sealed to the opposing package walls. Then at stomping stations 92, the ends of the zipper 36 for a given package are stomped. At a second sealing station 94, the folded film and zipper are cross-sealed to form discrete packages.

Because the zippers are closed, it is necessary to open the zippers in order to fill the packages. This is achieved at a slider opening station 96, where the slider is held in position as the zipper and film are advanced when the pull rollers 98 are activated. As the zipper moves through the slider, it is opened. Alternatively, the slider itself may be moved. Then, at a cutting station 100 the individual packages 102 are cut from one another. The separated packages 102 are then taken to the filling station 104 where they are filled. Filling may occur by means of a filling turret 106 or the packages may be filled in-line, both of which

techniques are well-known to those of ordinary skill in the art. After a package is filled, the slider 44 is moved backed to the closing end of the zipper. Finally, a tamper evident 108 seal may optionally be provided above the zipper 36. Completed slide-zippered packages 110 are then output from the machine.

A first variation of the fourth embodiment is shown in figure 13. As is clear from figure 13, the sliders are attached downstream of the folder plow 86, rather than upstream of the folder plow 86. Additionally, the sliders 44 are attached to the zippers 36 at their opening ends, rather than at their closing ends as above. Thus, in order to open the zippers for package filling the zippers must be forced open from the outside of the packages, rather than by using the sliders. This opening action is carried out at an opening station 97 by a suitable mechanism provided for the specific zipper construction. After filling at the filling station 104, the slider is moved to the closing end of the zipper.

A second variation of the fourth embodiment of the present invention is shown in figure 14. Under certain circumstances it may be desirable to eliminate the step of opening the zipper for filling. This can be done by sealing one zipper flange to one side of the folded film at the first sealing station 90 prior to filling, as shown in figure 15, rather than sealing both flanges to the film as done previously.

As shown in figure 15, one flange 40 of the zipper is sealed to one wall 116 of the folded film 82 a distance below the top 120. The film 82 protrudes above the zipper to form a pair of opposing ears 122. To ensure that the zipper flanges 40, 42 do not seal to each other or the other side of the package at the first sealing station 90, a J-shaped insulator plate 124 is inserted between the zipper flanges 40, 42 and between the unsealed zipper flange 42 and the

other package wall 118, as shown in figure 15. In addition, one of the seal bars 112 is kept hot and the other 114 is deactivated. Then, at the second sealing station 94, the packages are cross-sealed from the bottom of the film 92 up to but not including the zipper. When it comes time to fill the bag at the filling station 104, the zipper is bent to one side, as shown in figure 16. In this manner, filing may proceed unobstructed, and there is no danger of contaminating the zipper. After filling, the unsealed zipper flange 42 is sealed to the other side of the package and the ears 122 are sealed to each other by a pair of seal bars 126 with a perforation seal and a peel seal above the zipper 36, as shown in figure 17. At the same time the ends of the zipper are cross-sealed together and end stops for the slider are created. The above indicated zipper cross-seals extend below the zipper flanges into the package side seals, but not above and beyond the zipper profiles.

A third variation of the fourth embodiment of the present invention is shown in figure 18. In this variation, the zipper 36 and slider 44 are attached to the bottom 128 of the package, rather than at the top 120. As the film 82 is fed over the folder plow 86, a perforator 130 perforates the film 82 below the slider 44 to form a pair of perforations 132 (alternatively, a single perforation 132a may be provided). The zipper is then sealed to the bottom of the package by sealing the zipper flanges to the film beyond the perforation lines, as shown in figure 19. A peel seal 136 may be provided between the zipper flanges in order to maintain the integrity of the packages.

The packages are completed as discussed above, except that they are filled from the opposing end to which the zipper has been attached. Further, if a bottom gusset is required a V shaped film can be introduced between the package walls 116 and 118 and sealed into

place. During use, the packages are inverted so that the zipper and slider are at the top and the perforated portion 134 is torn away from the package to gain access to the slider.

Thus, in the foregoing manner the object of the present invention is achieved. Modifications to the above would be obvious to those of ordinary skill in the art, but would not bring the invention so modified beyond the scope of the appended claims.

CLAIMS

We claim:

1. A method of making reclosable packages, said method comprising the steps of:

feeding a supply of forming film in a package forming direction;

forming said forming film into a chain of bottom package portions and advancing said chain in said package forming direction;

feeding a supply of top film in said package forming direction;

laying said top film on to said chain of bottom package portions;

sealing said top film to said chain of bottom package portions to form a chain of packages, each of said packages including a pair of opposing film extensions on one side thereof which are not sealed to each other;

feeding a supply of interlocked reclosable zipper between the film extensions of said packages;

sealing a length of said reclosable zipper to the film extensions of each of said packages;

providing a supply of sliders, each of said sliders being insertable on to said reclosable zipper and adapted to open and close said reclosable zipper as said slider is moved along said zipper in opening and closing directions, respectively; and

for each of said packages, removing a slider from said slider supply and inserting said slider on to said reclosable zipper length.

2. The method according to claim 1 including the step of separating the film extensions of said packages prior to feeding said reclosable zipper therebetween.

3. The method according to claim 1 including the step of stomping the ends of said reclosable zipper lengths.

4. The method according to claim 1including the step of cutting each of said packages from said package chain.

5. The method according to claim 1 wherein each of said packages includes a peel seal adjacent its reclosable zipper.

6. A method of making packages having slide zippers, said method comprising the steps of:

providing a supply of packages, each of said packages having a reclosable zipper;

providing a supply of sliders, each of said sliders being insertable on to said reclosable zipper and adapted to open and close said reclosable zipper as said slider is moved along said reclosable zipper in opening and closing directions, respectively; and

for each of said packages, removing a slider from said slider supply and inserting said slider on to said reclosable zipper.

7. The method according to claim 6 wherein said packages are connected together in a chain.

8. The method according to claim 7 including the step of cutting each of said packages from said package chain.

9. A method of making reclosable packages, said method comprising the steps of:

feeding a supply of forming film in a package forming direction;

forming said forming film into a chain of bottom package portions, each of said bottom package portions having a lip on one side thereof;

advancing said chain of bottom package portions in said package forming direction;

feeding a supply of interlocked reclosable zipper in said package forming direction;

sealing a length of said reclosable zipper to the lip of each of said bottom portions;

providing a supply of sliders, each of said sliders being insertable on to said reclosable zipper and adapted to open and close said reclosable zipper as said slider is moved along said zipper in opening and closing directions, respectively;

for each of said bottom portions, removing a slider from said slider supply and inserting said slider on to said reclosable zipper length;

feeding a supply of top film in said package forming direction; and

sealing said top film to each bottom package portion and its corresponding length of reclosable zipper to form a chain of packages, each of said packages having a length of reclosable zipper and a slider.

10. The method according to claim 9 including the step of stomping the ends of said reclosable zipper lengths.

11. The method according to claim 9 including the step of cutting each of said packages from said package chain.

12. The method according to claim 9 wherein each of said packages includes a peel seal adjacent its reclosable zipper.

13. The method according to claim 9 wherein halves of said reclosable zipper are insulated from one another during said sealing steps.

14. The method according to claim 9 wherein said chain of bottom package portions is comprised of at least two parallel joined chains and wherein said top film is separated along pre-applied perforations and sealed to each of said parallel chains.

15. A method of making reclosable packages, said method comprising the steps of:

feeding a supply of package film in a package forming direction;

folding said package film about a bottom crease to form opposing package walls, said opposing package walls advancing in said package forming direction;

feeding a supply of interlocked reclosable zipper between said opposing package walls;

sealing said reclosable zipper to said opposing package walls;

providing a supply of sliders, each of said sliders being insertable on to said reclosable zipper and adapted to open and close said reclosable zipper as said slider is moved along said reclosable zipper in opening and closing directions, respectively;

removing sliders from said slider supply and inserting said sliders on to said reclosable zipper; and

cross-sealing said folded film at package-width intervals to form a chain of packages, each of said packages having a reclosable zipper and a slider.

16. The method according to claim 15 wherein said sliders are inserted on to said reclosable zipper prior to said reclosable zipper being fed between said opposing package walls.

17. The method according to claim 15 wherein said sliders are inserted on to said reclosable zipper after said zipper is fed between said opposing package walls.

18. The method according to claim 16 wherein said reclosable zipper is sealed to said opposing package walls adjacent said bottom crease.

19. The method according to claim 15 including the additional steps of:

opening the reclosable zipper of each package;

filling each package; and

closing the reclosable zipper of each package.

20. The method according to claim 19 wherein the reclosable zipper of each package is opened by moving its slider from a closing end of the reclosable zipper to an opening end of the reclosable zipper.

21. The method according to claim 19 wherein the reclosable zipper of each package is opened by holding its slider in place as the package film is advanced in the package forming direction.

22. The method according to claim 19 wherein the reclosable zipper of each package is closed my moving its slider from an opening end of the reclosable zipper to a closing end of the reclosable zipper.

23. The method according to claim 19 wherein the reclosable zipper of each package is opened by means other than the slider.

24. The method according to claim 15 including the step of sealing each package above its reclosable zipper to form a tamper evident seal.

25. The method according to claim 15 including the step of cutting each of said packages from said chain of packages.

26. The method according to claim 15 wherein the ends of the reclosable zipper of each package are cross-sealed.

27. The method according to claim 15 wherein said reclosable zipper supply is stomped at package width intervals.

28. A method of making reclosable packages, said method comprising the steps of:

feeding a supply of package film in a package forming direction;

folding said package film about a bottom crease to form opposing package walls, said opposing package walls advancing in said package forming direction;

feeding a supply of interlocked reclosable zipper between said opposing package walls;

sealing one-half of said reclosable zipper to a first of said package walls;

providing a supply of sliders, each of said sliders being insertable on to said reclosable zipper and adapted to open and close said zipper as said slider is moved along said zipper in opening and closing directions, respectively;

removing sliders from said slider supply and inserting said sliders on to said reclosable zipper;

cross-sealing said folded film at package-width intervals to form a chain of packages, each of said packages having a reclosable zipper and a slider;

filling each of said packages; and

sealing the unsealed half of the reclosable zipper of each of said packages to the other

package wall.

29. The method according to claim 28 including the step of bending the reclosable zipper of each of said packages toward the package wall to which it is sealed prior to filling said package.

30. The method according to claim 28 wherein during the sealing of said one-half of said reclosable zipper to said first package wall said reclosable zipper is insulated from the other package wall.

31. The method according to claim 28 wherein during sealing of said one-half of said reclosable zipper to said first package wall said one-half of said reclosable zipper is at least partially insulated from the other half of said reclosable zipper.

32. The method according to claim 28 including the step of cross-sealing the ends of the reclosable zipper of each package.

33. The method according to claim 28 wherein said zipper cross-seals extend into said package cross-seals.

ABSTRACT

Methods of making slide-zippered reclosable packages are provided. In one embodiment, a pair of opposing film extensions are provided on each package between which a zipper and slider are attached. In another embodiment, sliders are inserted on to zippered packages output from a form-fill-seal machine or the like. In yet another embodiment, during package formation a reclosable zipper is sealed to each package and then a slider is inserted on to the zipper. In yet another embodiment, during package formation a reclosable zipper is sealed to each package and a slider is inserted on to each zipper, either before or after zipper sealing.

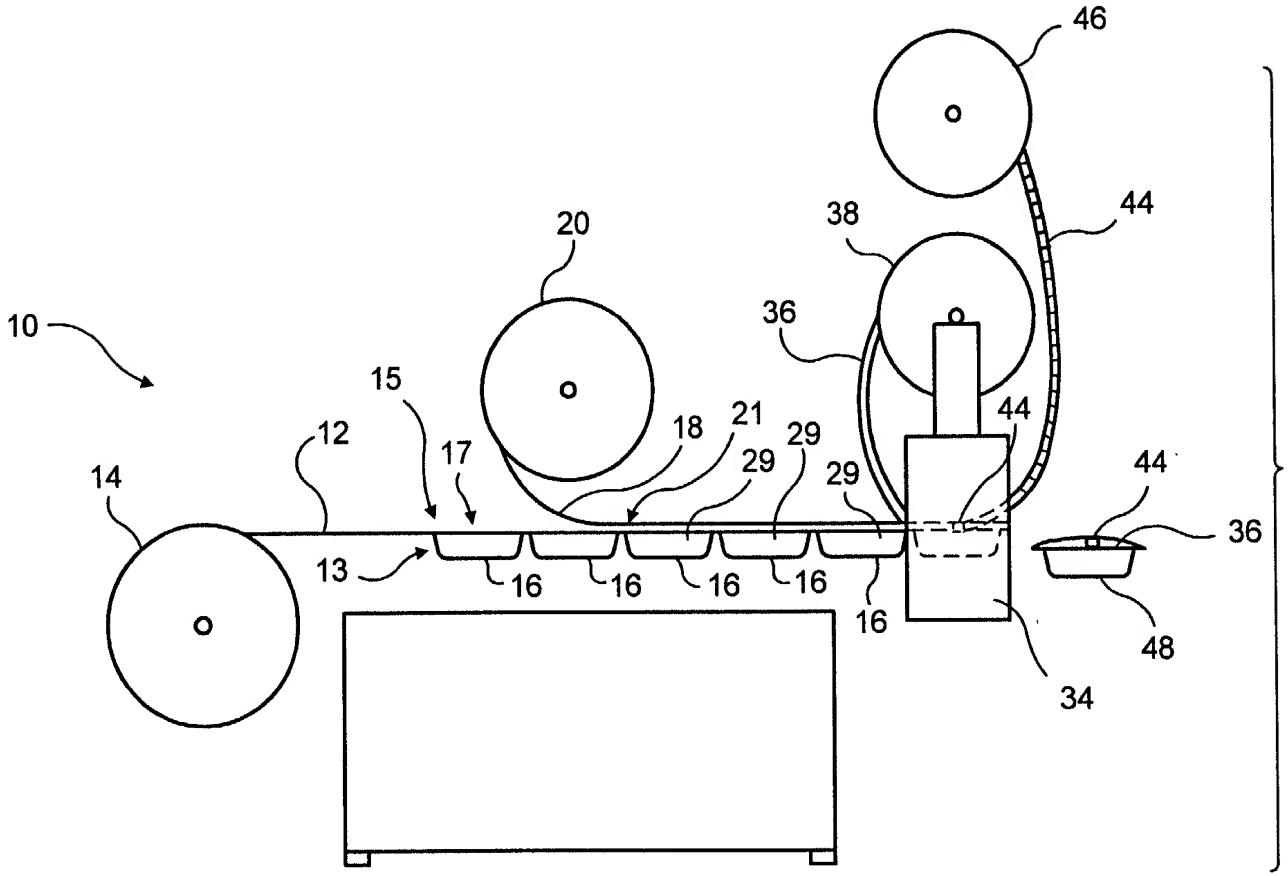


FIG. 1

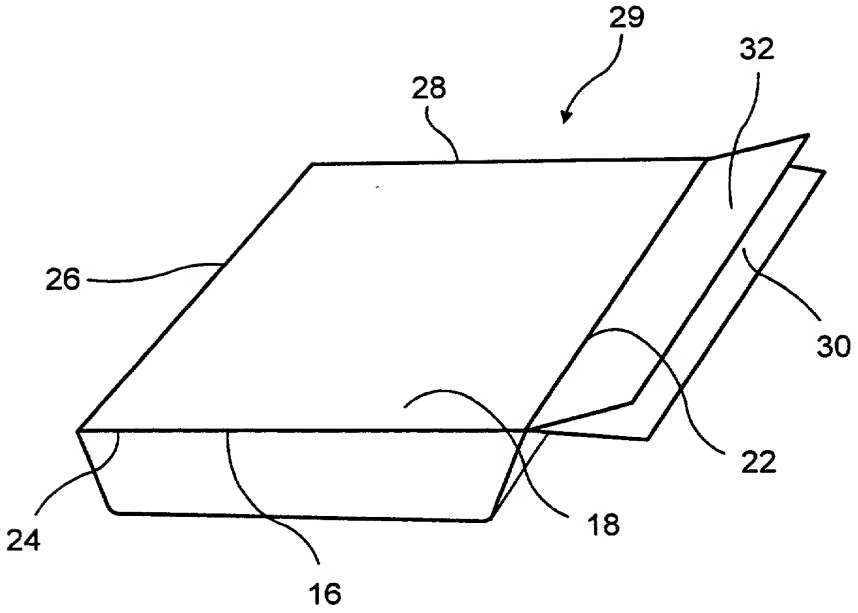
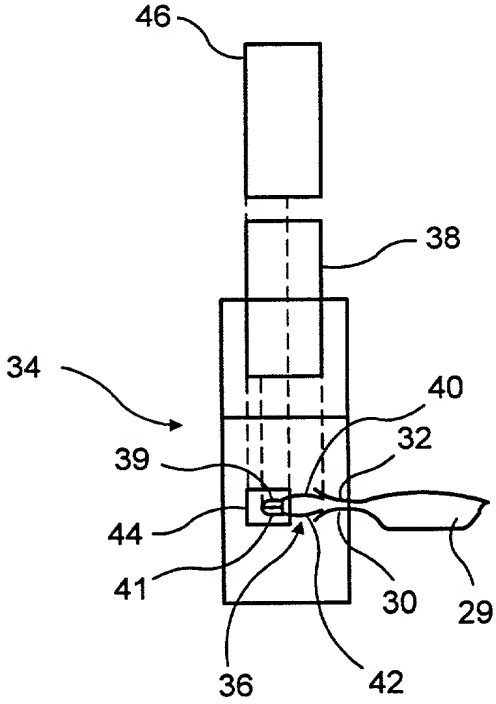


FIG. 2



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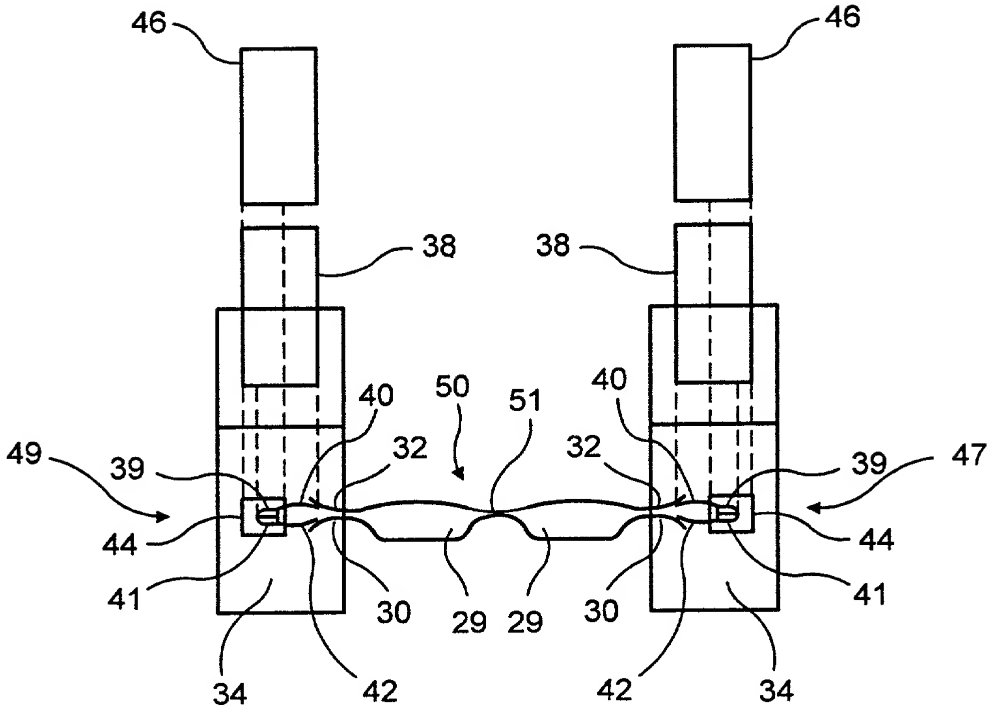
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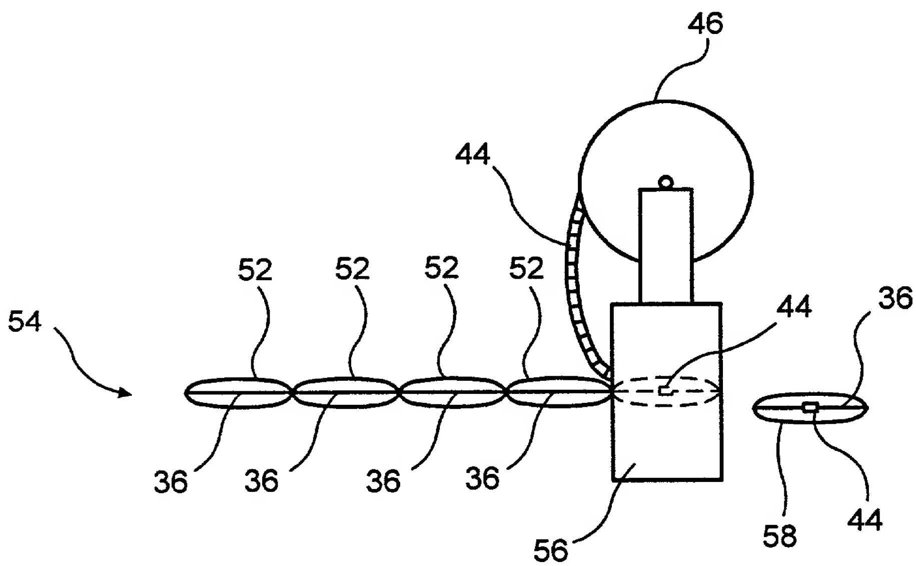
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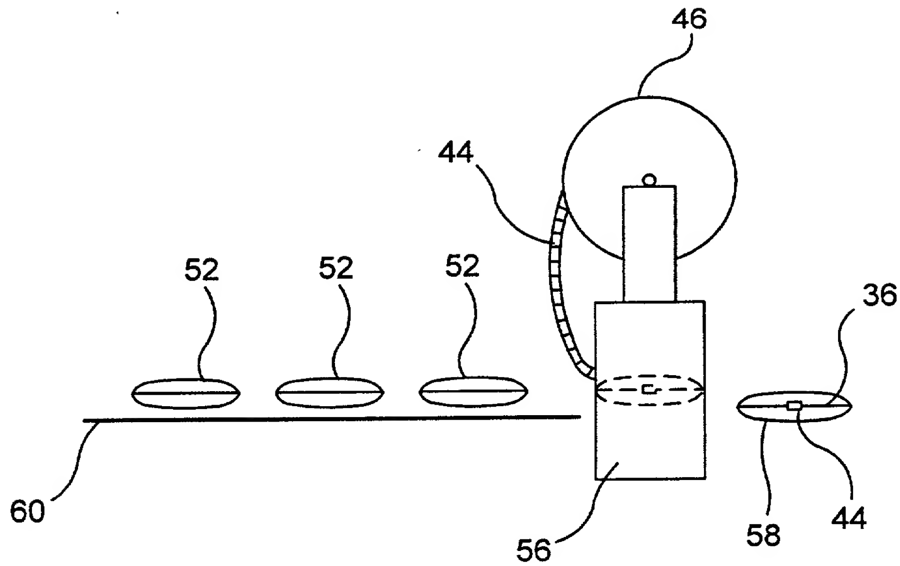

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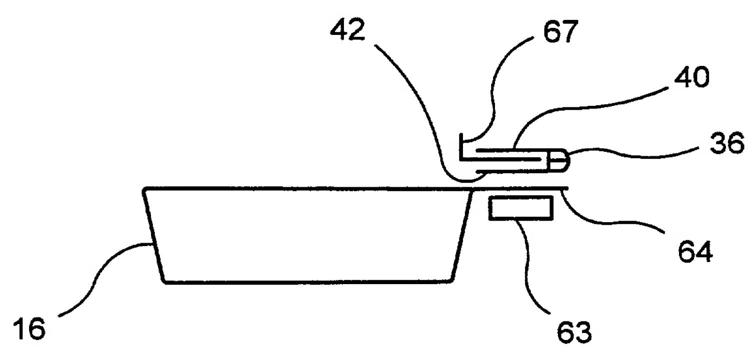

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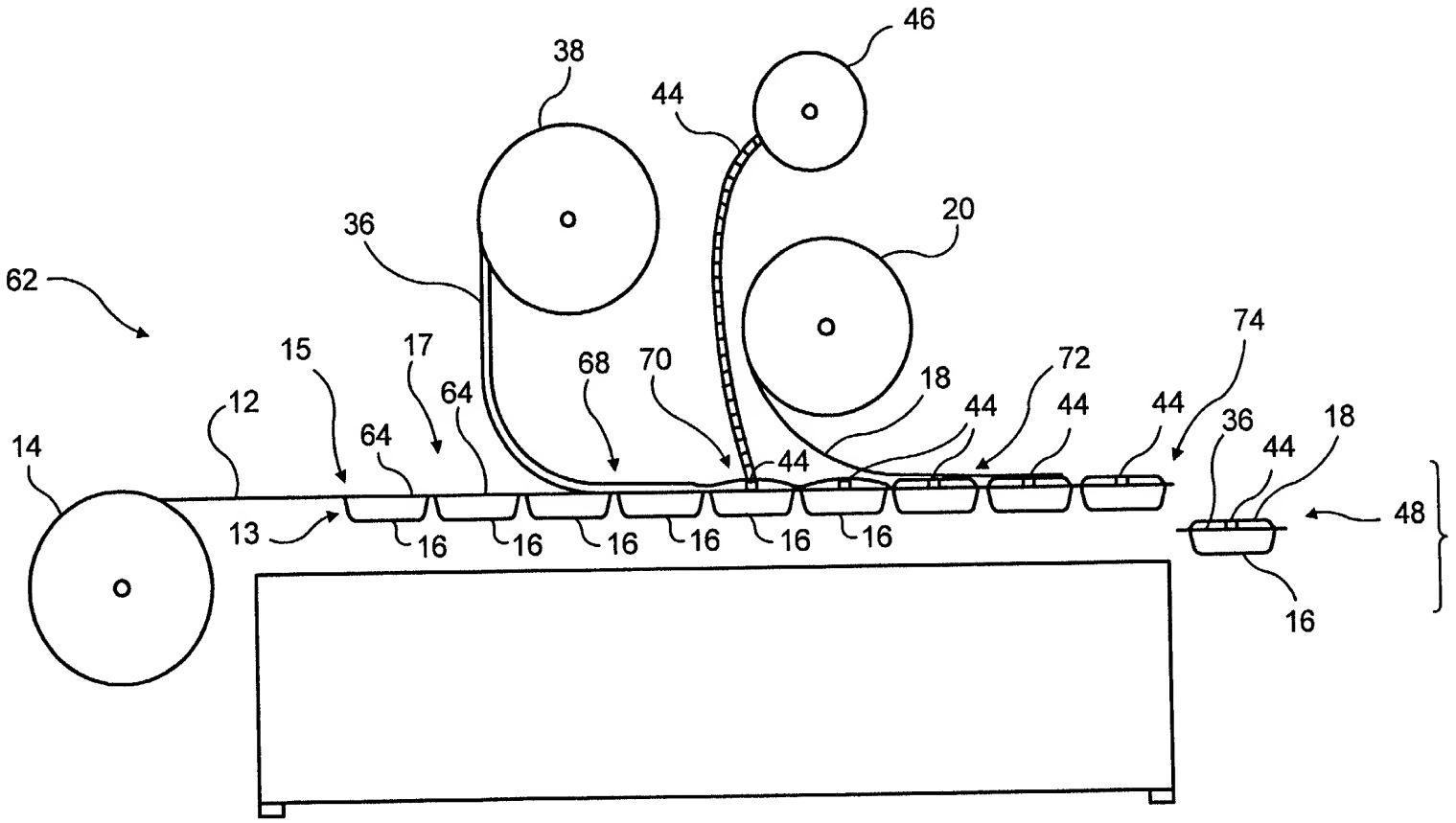
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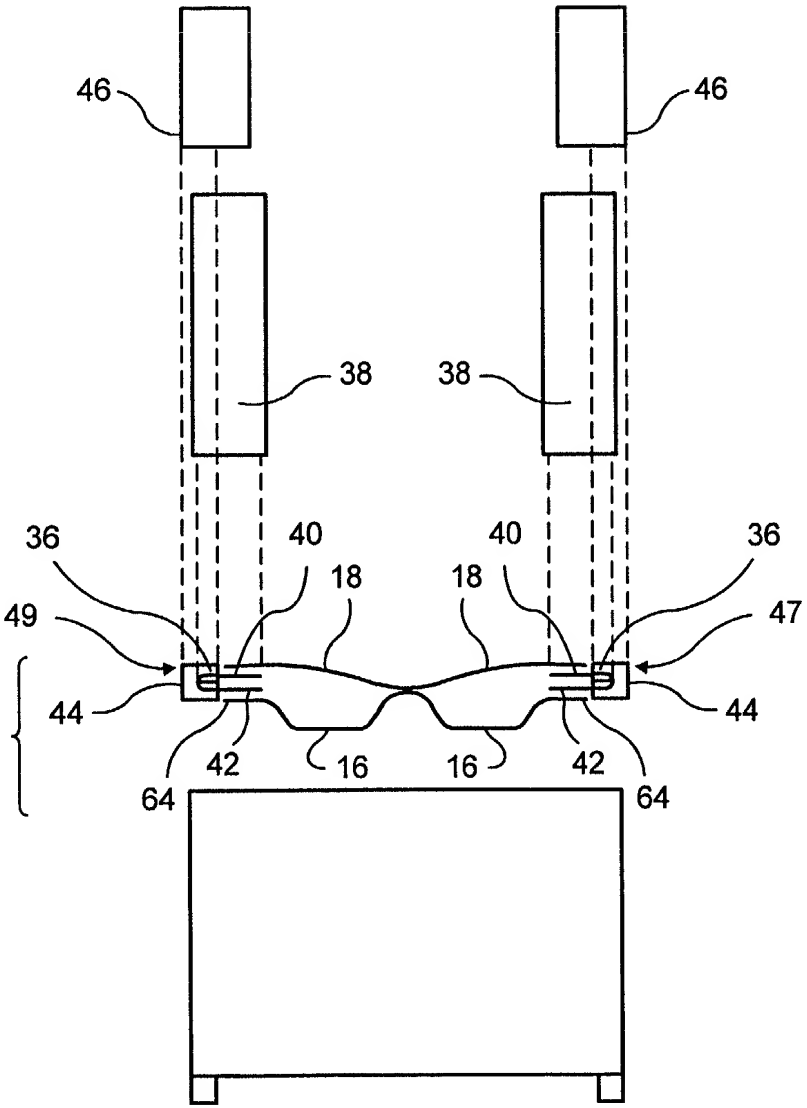
FIG. 7



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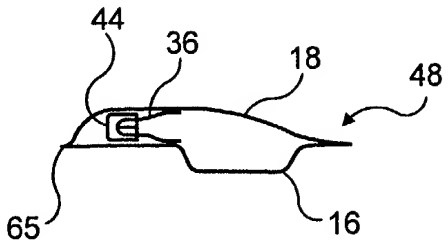

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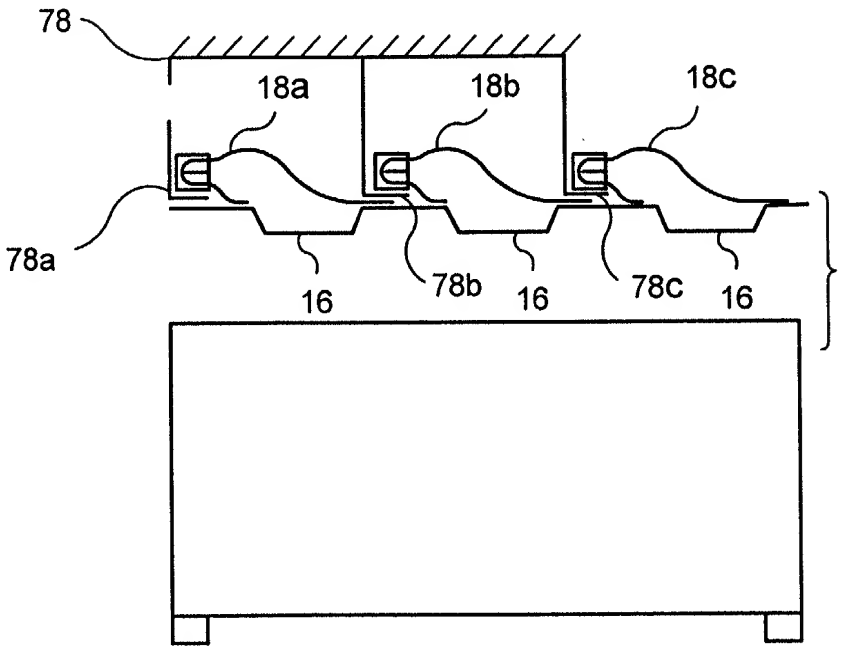
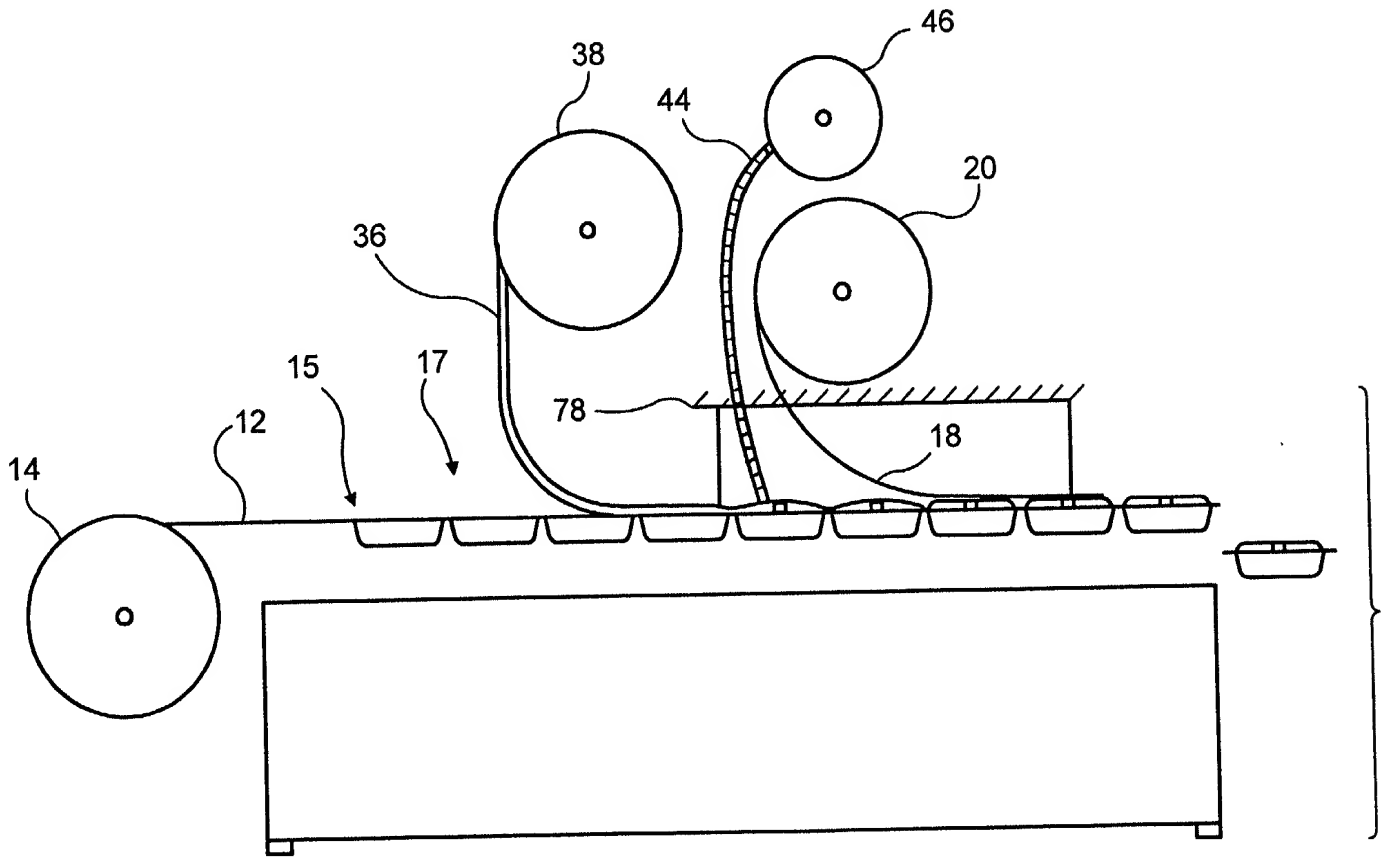


FIG. 11



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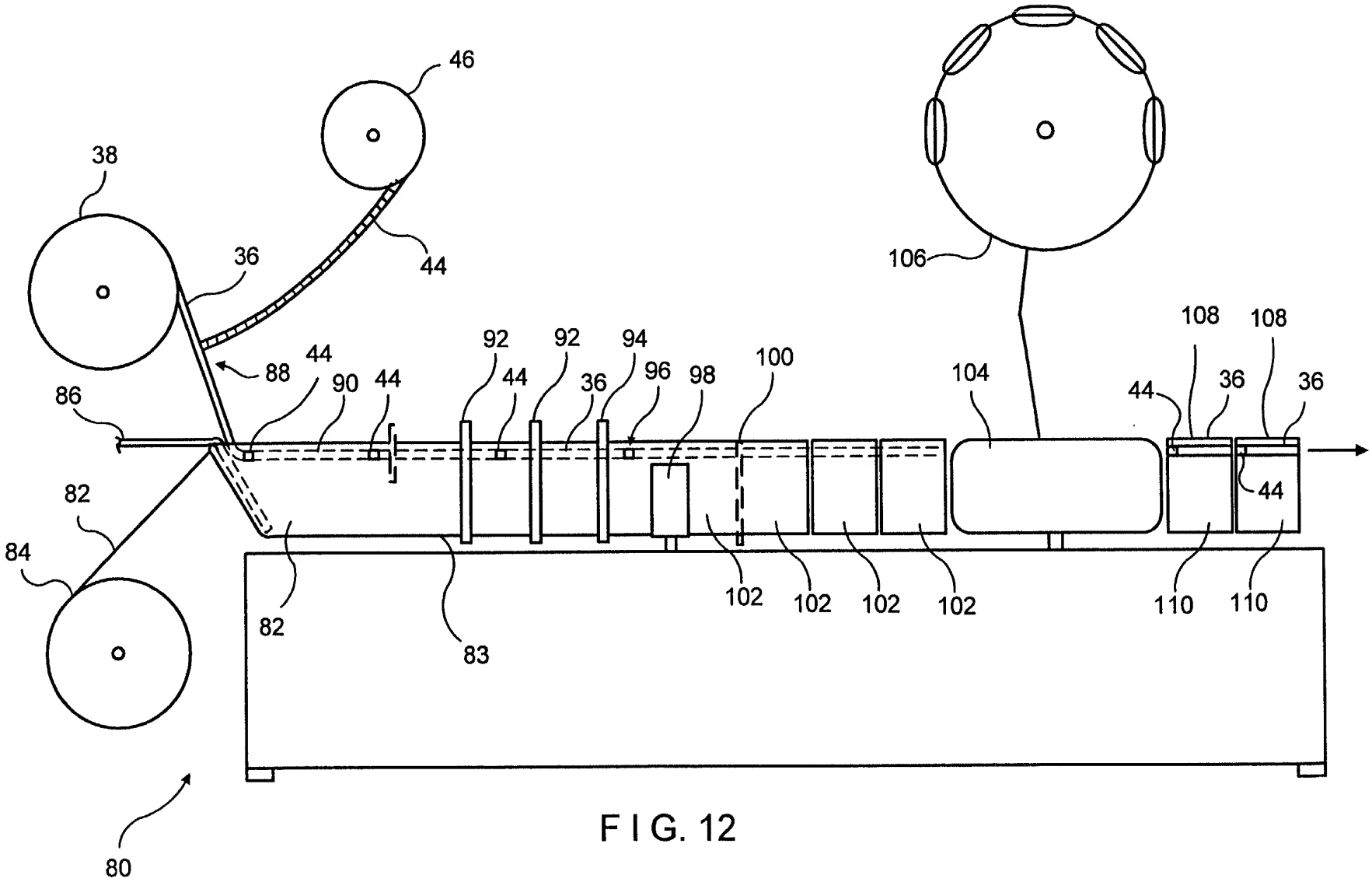
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FIG. 12

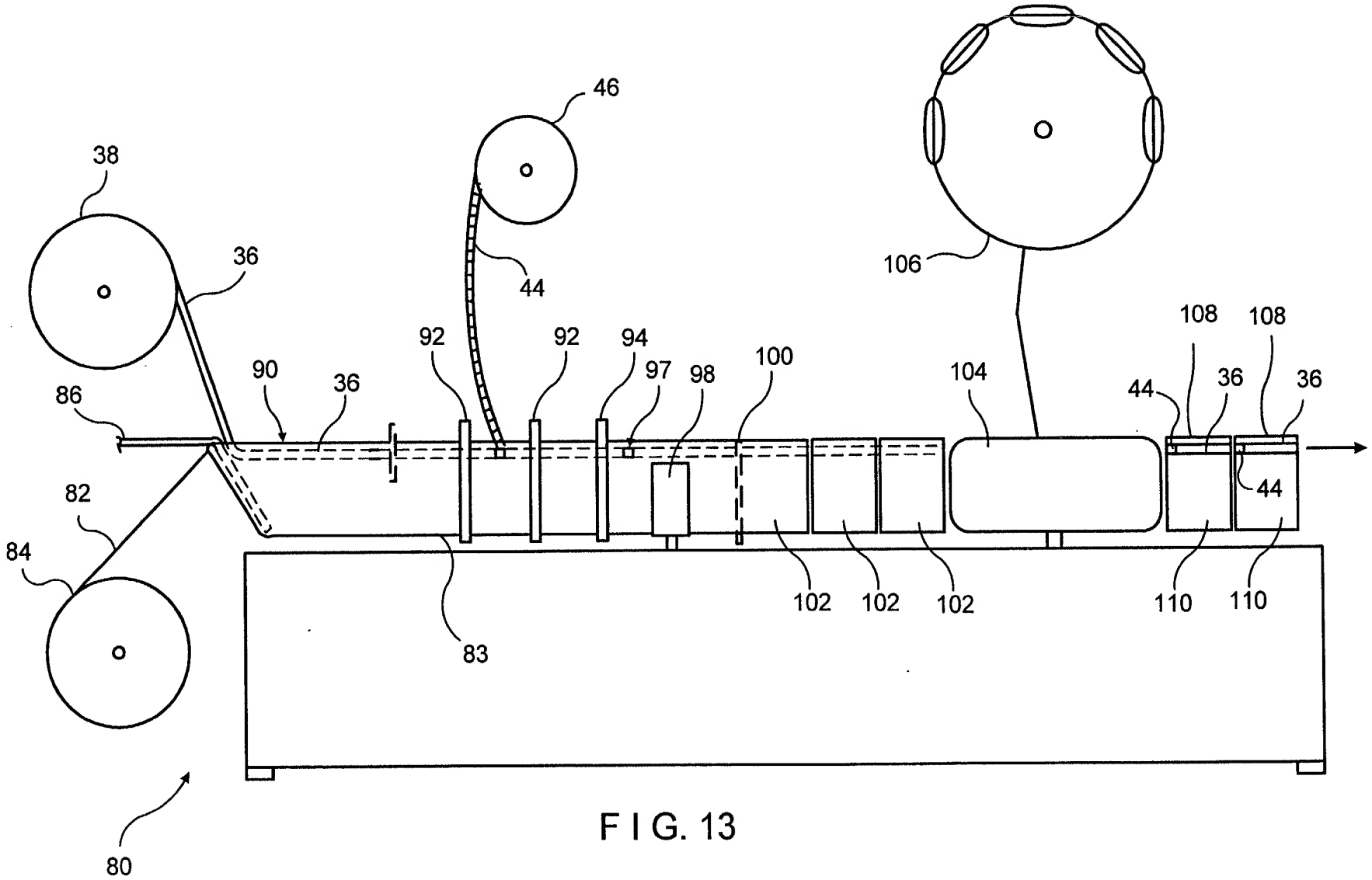

FIG. 13

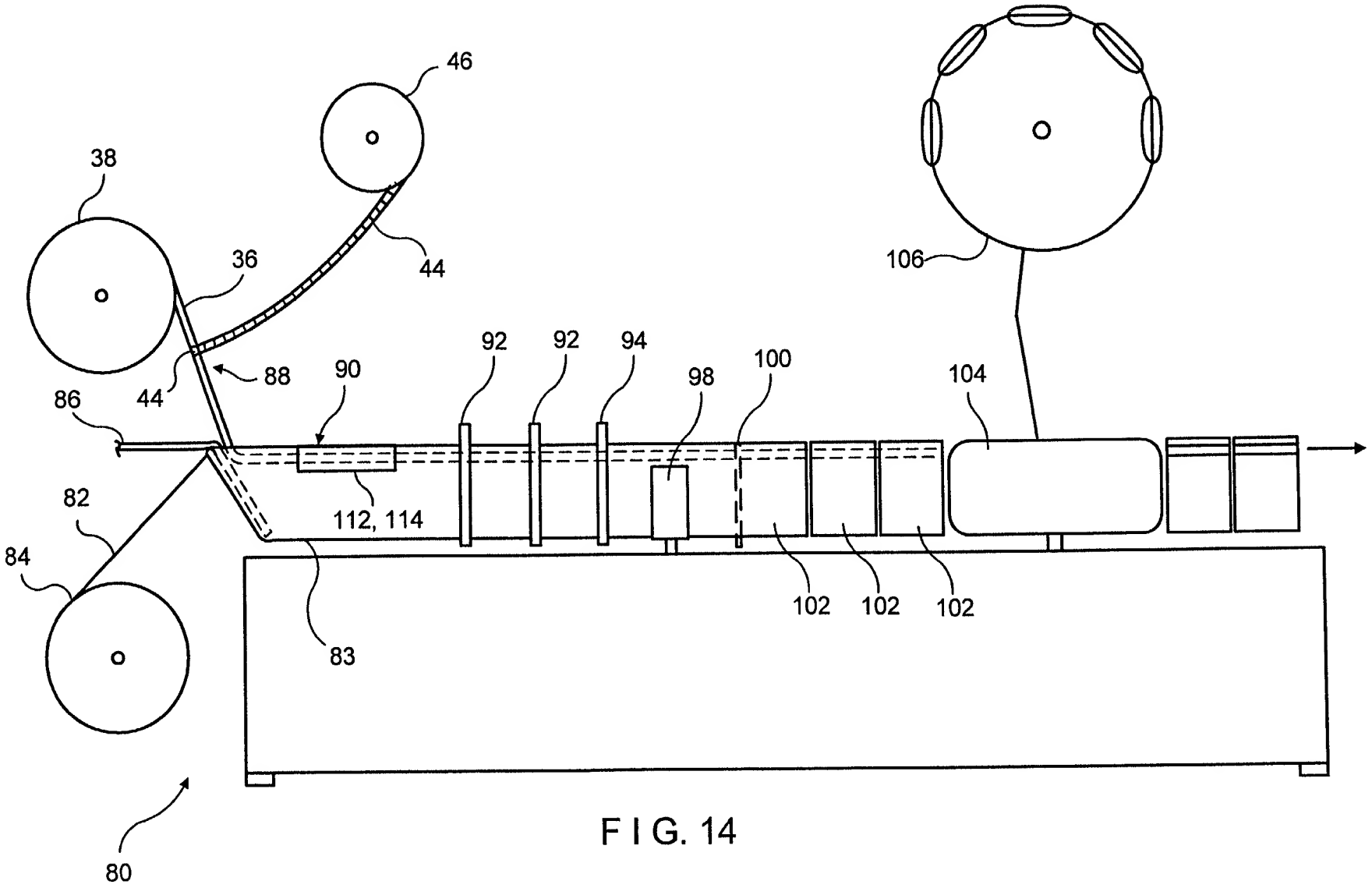
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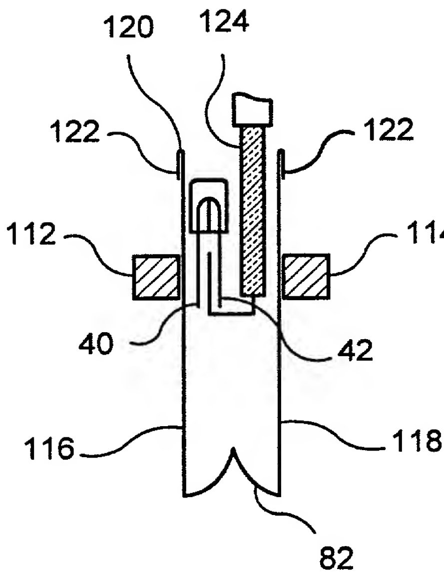
FIG. 14



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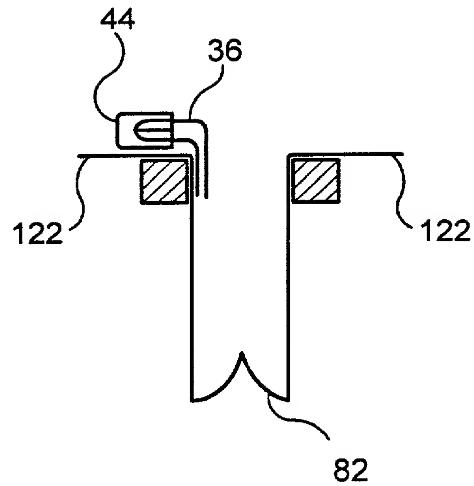

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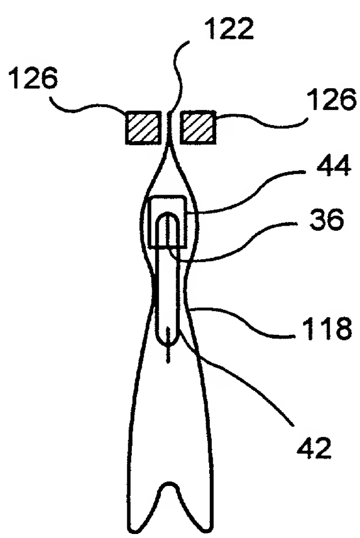

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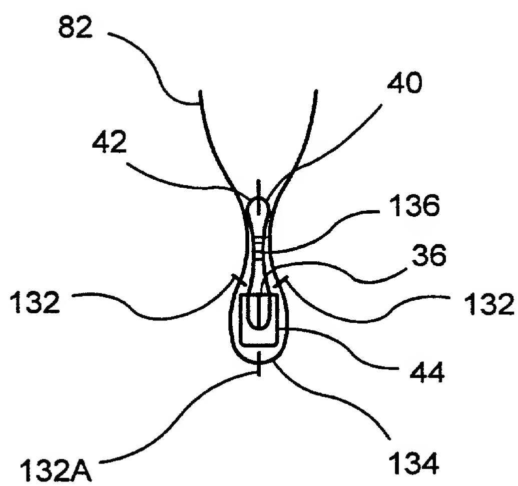

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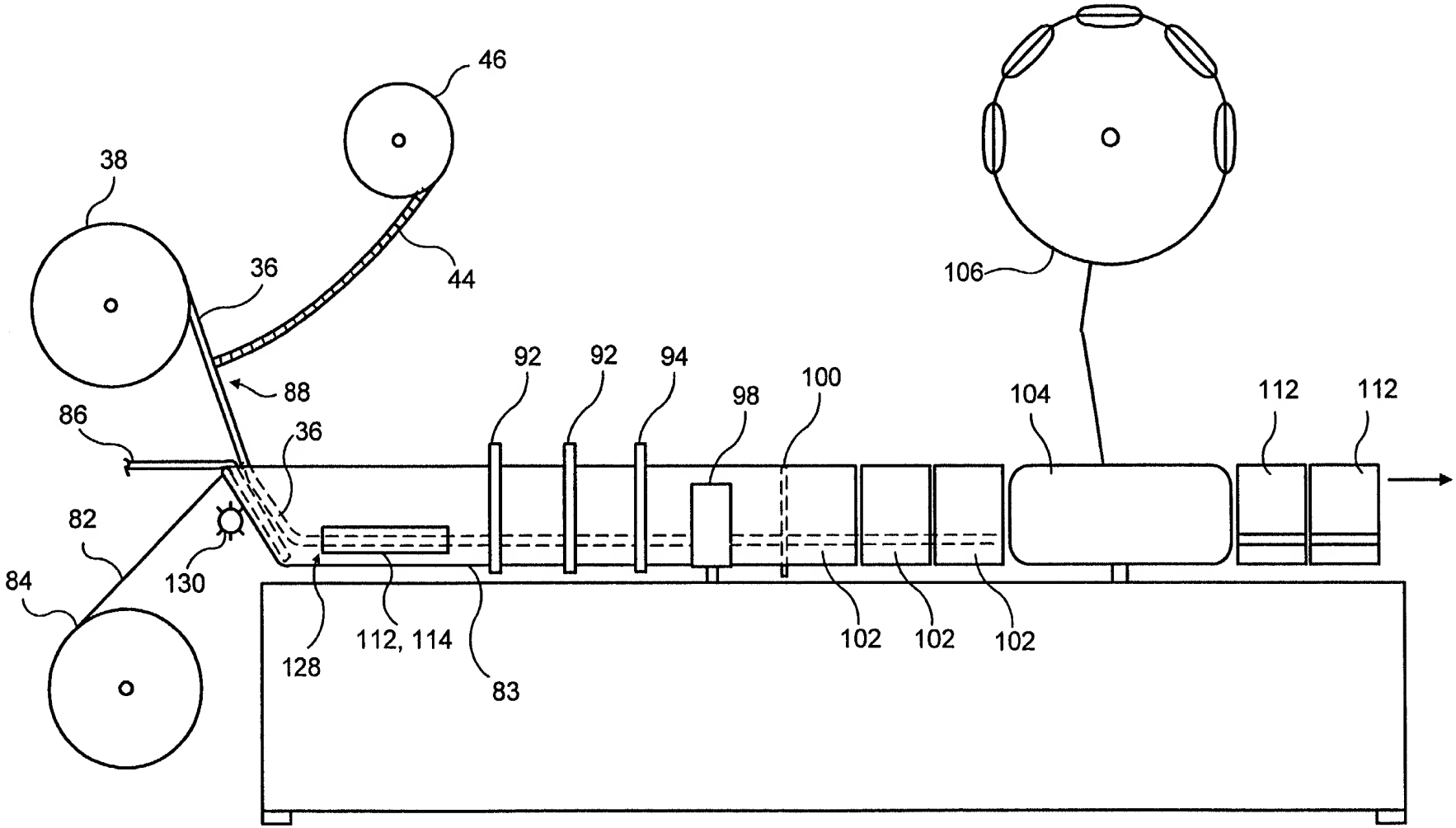

FIG. 18

Docket No. **769-236**

COMBINED DECLARATION AND POWER OF ATTORNEY FOR PATENT APPLICATION

As a below named inventor(s), I (We) hereby declare that:
My (Our) residence, post office address and citizenship are as stated below next to my (our) name(s). I (We) believe I (we) am (are) the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled **METHODS OF MAKING SLIDE-ZIPPERED RECLOSABLE PACKAGES ON HORIZONTAL FORM-FILL-SEAL MACHINES**, the specification of which is attached hereto unless the following is checked:

X was filed on **May 21, 1999** as United States Application

Number or PCT International Application Number **09/316,866**

and was amended on _____ (if applicable).

I (We) hereby state that I (we) have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I (We) acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, §1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed.

PRIOR FOREIGN APPLICATION(S)			
NUMBER	COUNTRY	DATE FILED	PRIORITY CLAIMED
			YES NO
			YES NO
			YES NO

I (We) hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, §1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application.

APPLICATION NO.	FILING DATE	STATUS PATENTED,PENDING, ABANDONED

I (We) hereby declare that all statements made herein of my (our) own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

I (We) hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith: Joseph C. Sullivan, Registration No. 18,720; Gerald Levy, Registration No. 24,419; Ronald R. Santucci, Registration No. 28,988; Ronald E. Brown, Registration No. 32,200; John Gulbin, Registration No. 33,180; Richard J. Danyko, Registration No. 33,672; Monami D. Roy, Registration No. 40,892; Tod M. Melgar, Registration No. 41,190; and Clifford A. Ulrich, Registration No. 42,194. ***I (We) further authorize my (our) attorney to insert the proper serial number and filing date awarded to my (our) application on this document, above my (our) signature(s).**

SEND CORRESPONDENCE TO: **Gerald Levy, Esq.**

KANE, DALSIMER, SULLIVAN, KURUCZ,
LEVY, EISELE AND RICHARD
711 Third Avenue
New York, New York 10017-4059

DIRECT TELEPHONE CALLS TO: Gerald Levy

(212) 687-6000

FULL NAME OF SOLE OR FIRST INVENTOR	CITIZENSHIP
Michael J. McMahon	United States
INVENTOR'S SIGNATURE Michael J. McMahon	DATE July 16, 1999
RESIDENCE 606 Parkside Drive, Palatine, Illinois 60067	
POST OFFICE ADDRESS 606 Parkside Drive, Palatine, Illinois 60067	

FULL NAME OF SECOND JOINT INVENTOR, IF ANY Art Malin	CITIZENSHIP United States
INVENTOR'S SIGNATURE	DATE 7-16-99
RESIDENCE 1840 Smith Road, Northbrook, Illinois 60062	
POST OFFICE ADDRESS 1840 Smith Road, Northbrook, Illinois 60062	

FULL NAME OF THIRD JOINT INVENTOR, IF ANY Steve Ausnit	CITIZENSHIP United States
INVENTOR'S SIGNATURE	DATE 7/19/99
RESIDENCE 124 East 61st Street, New York, New York 10021	
POST OFFICE ADDRESS 124 East 61st Street, New York, New York 10021	

FULL NAME OF FOURTH JOINT INVENTOR, IF ANY	CITIZENSHIP
INVENTOR'S SIGNATURE	DATE
RESIDENCE	
POST OFFICE ADDRESS	